

Work Order ID 60254

Wednesday, June 30, 2010 8:18:21 AM

Page 1

Item ID: D407-667-105TRN

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Turning Detail

Start Date: 6/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 7/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-30

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D407-667-145

Rev C

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio
FA249□2-Turn first side as per Folio FA249□3- File transition lines smooth.

Q.M. 10-06-300

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

Q.M. 10-06-300

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA249□2- File transition lines smooth.□3-
Remove sand and plugs□4-Scribe part # and batch # using vibrating stylus as
per Dwg D206-667-145 □Inside of Cuff(Do not engrave on outside of tube)

Q.M. 10-06-300

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

G.M. 10-06-30 @

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

1 - 10.07 @

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

(14) Q* MB 10-07-07

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Page 3

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Cust Item ID:

Required Date: 7/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 M 10/7/10

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in Kanban rack Location: X-tube cal

OK & MB 10-07-07

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MB 10-7-7

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 30, 2010 8:18:27 AM

Page 1

Work Order ID: 60254



Parent Item: D407-667-105TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 6/30/2010

Required Date: 7/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:a 08.02.28 new issue EC
IPP Rev B 08.04.02 Removed polish EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D6010-115

Manufactured

No

110

Each

45.0000

1

1



Crosstube Material

Q. M 10-06-30

Location

Loc Qty

Loc Code

LG

45

26424

2

38343

43

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|-------------------------------------|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 40234 |
| Description: Crosstube Assembly | | Part Number: D407-667-145 |
| Inspection Dwg: D407-667-145 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| SIDE A | 2.240 | +0.005/-0.000 | 2.240 | / | | | |
| | 1.865 | +0.005/-0.000 | 1.870 | / | | | |
| | 1.878 | +0.005/-0.000 | 1.883 | / | | | |
| | 1.970 | +0.005/-0.000 | 1.975 | / | | | |
| | 2.030 | +0.005/-0.000 | 2.035 | / | | | |
| | 2.165 | +0.005/-0.000 | 2.170 | / | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | 0.125 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | R0.500 | +/-0.010 | R0.500 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | 4.438 | +/-0.010 | 4.438 | / | | | |
| | | | | | | | |
| | | | | | | | |
| SIDE B | 2.240 | +0.005/-0.000 | 2.240 | / | | | |
| | 1.865 | +0.005/-0.000 | 1.870 | / | | | |
| | 1.878 | +0.005/-0.000 | 1.883 | / | | | |
| | 1.970 | +0.005/-0.000 | 1.975 | / | | | |
| | 2.030 | +0.005/-0.000 | 2.035 | / | | | |
| | 2.165 | +0.005/-0.000 | 2.170 | / | | | |
| | | | | | | | |
| | 0.125 | +/-0.010 | 0.125 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | R0.500 | +/-0.010 | R0.500 | / | | | |
| | R0.063 | +/-0.010 | R0.063 | / | | | |
| | 4.438 | +/-0.010 | 4.438 | / | | | |
| | 113.20 | +/-0.020 | 113.200 | / | | | |
| | | | | | | | |
| | | | | | | | |

| | | | |
|------------------------|------------------------|---------------------|-----|
| Measured by: <i>AM</i> | Audited by: <i>AWD</i> | Prototype Approval: | N/A |
| Date: 10.06.20 | Date: 10.07.07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|--------------|----------|
| A | 04.04.21 | New Issue (P/O D407-667-105) | KJ/RF | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | |
| C | 09.06.11 | Dwg Rev updated | KJ <i>JS</i> | <i>M</i> |

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NOTE: Date & initial all entries

| Item | Qty -145 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D407-667-145 | CROSSTUBE ASSEMBLY (407 HIGH FWD) |
| 2 | 1 | D6010-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 60254
BJ 10-6-29

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
03/11/12

| | | | |
|------------|---|---|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 02.05.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D407-667-145 | SHEET 1 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | CROSSTUBE ASS'Y (407 HIGH FWD) | NTS |
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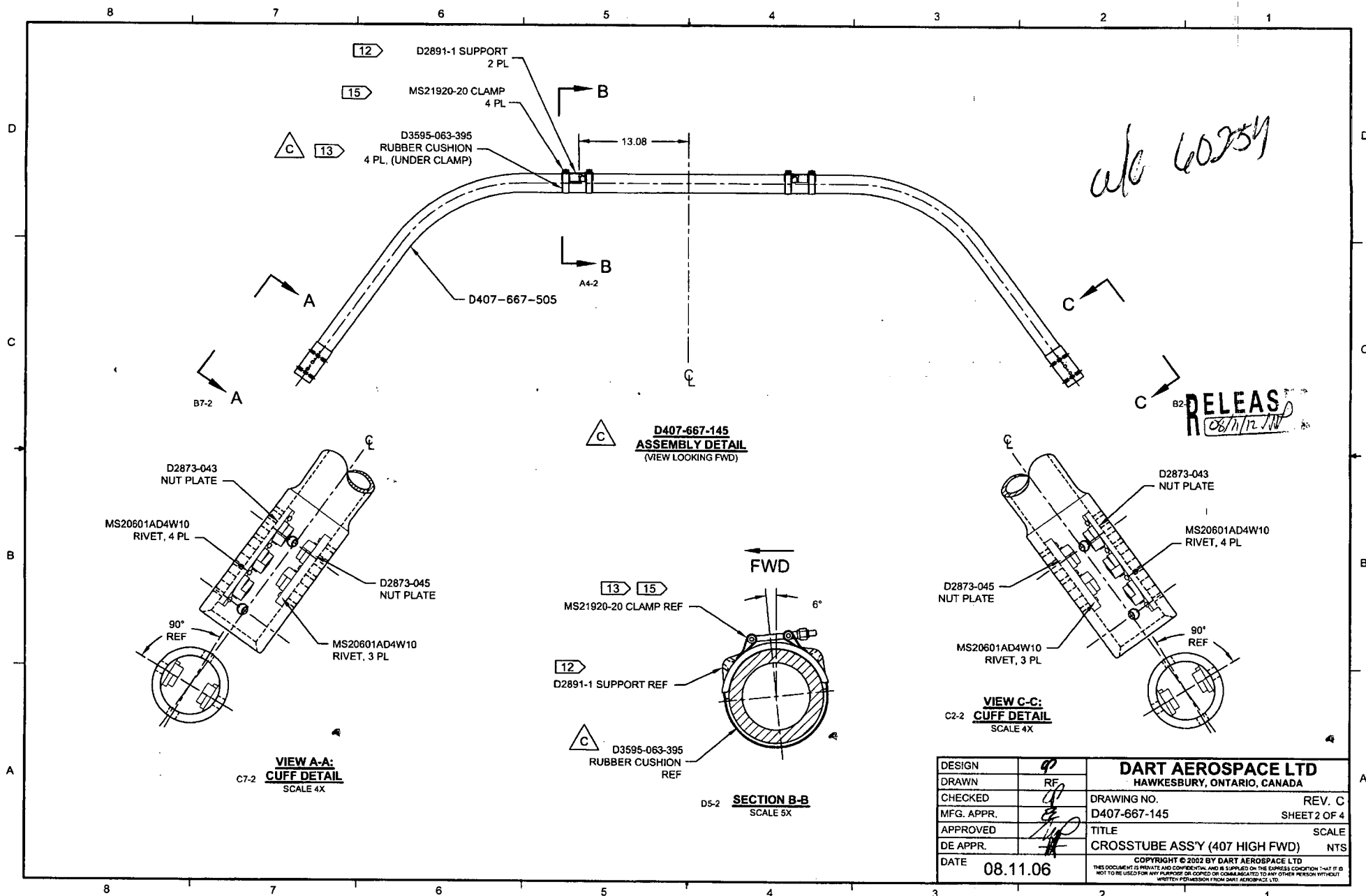
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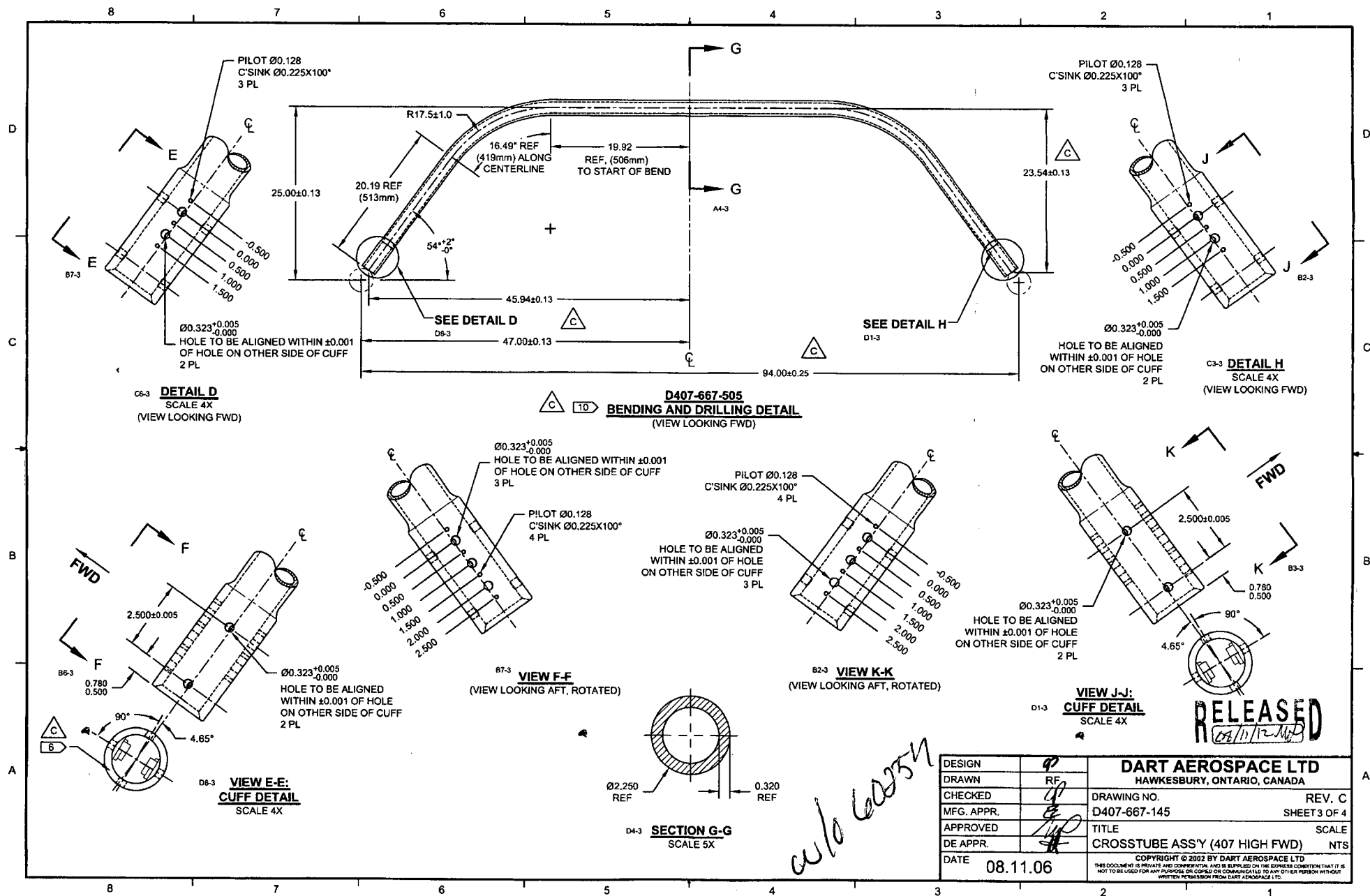
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| DESIGN | <i>P</i> | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>P</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>P</i> | D407-667-145 | SHEET 3 OF 4 |
| APPROVED | <i>P</i> | TITLE | SCALE |
| DE APPR. | <i>P</i> | CROSSTUBE ASS'Y (407 HIGH FWD) | NTS |
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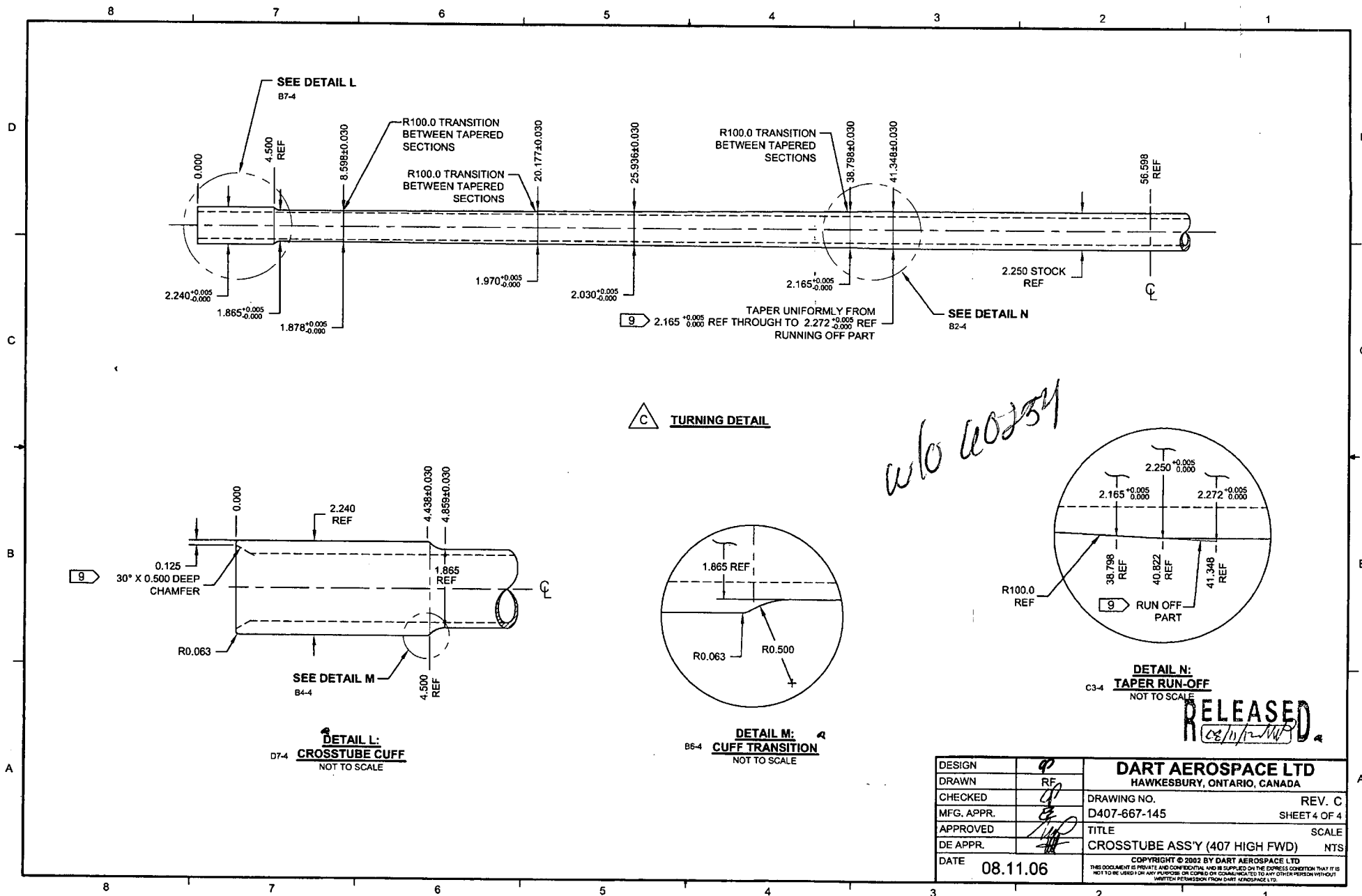
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| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D407-667-145 | SHEET 4 OF 4 |
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